

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024054**Date Inspected:** 28-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for random observations relative to the work being performed.

Trial Assembly

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member was identified as OBG13AW and OBE13AE. The weld designations reviewed are as follows:

SEG3009L-025,026,028,029,031,032,034,035,037, 038,039,011,141,012,040,046,048,041,140

SEG3007Y-461,326,319,328,320,327,331,358,360, 362,364,366,368, 370,372,374,376,325,324,333

SEG3007AE-017,018,037,038,097,098,019,020,099,100,039,040

SEG3007AH-084,022,023,024,036,037,038,039,066,067,068,069,053,054,055,056,163,164,165,087, 094,095, 096,097,114,115,116,117,104,105,106,107

FB3124-001-029,030,033,034

This QA Inspector observed the following work in progress for Trial Assembly.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Zhong Lin.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 14W

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PCMK: SEG3020D

Weld No: 001,002,305,306,307,308

Welder: 068917

WPS-B-P-2114-FCM-1

Components; OBG 13AW

PCMK: SEG3013AH

Weld No: 032

Welder: 066673

WPS-B-P-2212-TC-U4b-2114-FCM-1

Components; OBG 13AW

PCMK: AH3001

Weld No: 092,093

Welder: 070009

WPS-B-P-2114-FCM-1

This QA Inspector observed the following work in progress for Trial Assembly.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Zhen Hal Fong.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 14E

PCMK: SEG3019AH

Weld No: 003

Welder: 215553

Repair No. B-WR21107

WPS-345-SMAW-2G(2F)-FMC-Repair-1

Components; OBG 14E

PCMK: SEG3019W

Weld No: 014,139

Welder: 216086

WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 13CE

PCMK: DP3108-001

Weld No: 036

Welder: 051359

WPS-B-P-2113-FCM-1

Components; OBG 13CE

PCMK: DP3109-001

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Weld No: 036
Welder: 051359
WPS-B-P-2113-FCM-1

Components; OBG 13BE
PCMK: SEG3009J
Weld No: 036
Welder: 058102
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 13BE
PCMK: SEG3009G
Weld No: 004
Welder: 058102
WPS-B-P-2214-TC-U4b-FCM-1

This QA Inspector observed the following work in progress for Trial Assembly.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Zhen Hal Fong.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Components; OBG 14E
PCMK: SEG3019BB
Weld No: 078,100
Welder: 055491
Weld Repair No. B-WR20764
WPS-345-FCAW-3G(3F)-ESAB-Repair-1

Components; OBG 14E
PCMK: SA3036-001~006
Weld No: 005,008
Welder: 069866
WPS-FCAW-2231-ESAB

This QA Inspector observed the following work in progress for Trial Assembly.
ZPMC was using the Shielded Metal Arc Welding (SMAW) process.
ZPMC QC is identified as Wang Xiang Pin.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Components; OBG 13CW
PCMK: SEG3015B
Weld No: 271

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Welder: 037998
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 14W
PCMK: SEG3020AW
Weld No: 086
Welder: 037998
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 13CW
PCMK: VP3014-001
Weld No: 042
Welder: 067829
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 13CW
PCMK: VP3015-001
Weld No: 011
Welder: 067829
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 13CW
PCMK: VP3018-001
Weld No: 003
Welder: 067570
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 13CW
PCMK: VP3019-001
Weld No: 008
Welder: 067570
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 14E
PCMK: OBW13B
Weld No: 005
Welder: 066398
Repair No. B-WR21077
WPS-345-SMAW-3G(3F)-FMC-Repair-1

Components; OBG 13AE
PCMK: SEG3007C
Weld No: 214
Welder: 044772

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Repair No. B-WR20983
WPS-345-SMAW-3G(3F)-FMC-Repair-1

Components; OBG 13AE

PCMK: VP3002-001

Weld No: 001,004

Welder: 044772

Repair No. B-WR20983

WPS-345-SMAW-2G(2F)-FMC-Repair-1

Components; OBG 13AE

PCMK: OBE12AD

Weld No: 001

Welder: 044772

Repair No. B-WR21119

WPS-345-SMAW-3G(3F)-FMC-Repair-1

This QA Inspector observed the following work in progress for Trial Assembly.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Wang Xiang Pin.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 13AW

PCMK: KP3014-001

Weld No: 003

Welder: 067876

WPS-B-T-2232-TC-U4B-FCM-1

Components; OBG 13AW

PCMK: KP3016-001

Weld No: 004,006

Welder: 067876

WPS-B-T-2232-TC-U4B-FCM-1

Components; OBG 13AW

PCMK: KP3017-001

Weld No: 003

Welder: 067876

WPS-B-T-2232-TC-U4B-FCM-1

Components; OBG 13AW

PCMK: KP3018-001

Weld No: 003,005

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Welder: 067876

WPS-B-T-2232-TC-U4B-FCM-1

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

“No relevant conversations.”

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By:	Leavitt,Kelly
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Quality Assurance Inspector

Reviewed By:	Riley,Ken
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QA Reviewer
